

Abstract

A pocket drilling fixture has a clamp base with a clamping face formed thereon. Opposing the clamp base is a clamp body with an opposing clamping face. Clamp structure interengages the clamp body and the base. The clamp structure includes a clamp actuator positioned adjacent to the base to move the clamp body in a clamping direction. A guide carrier has at least one drill guide disposed therein, and has an axis which intersects a plane defined by the clamping face. The guide carrier is mounted on the base to move in the direction parallel to the plane. The base may have formed thereon a turret having multiple surfaces for height adjustment. The turret may be positioned under the guide carrier to set its height above the base so that height can be preselected, depending on the workpiece thickness.